

Work Order ID 81572

March-15-12 1:01:03 PM

81572

Page 1

Item ID: D350-607-143

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012 Start Qty: 2.00

2

Required Date: 13/04/2012 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/15

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-607-143
CHG001*N/A*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

*2x**SP 12-04-16*

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

*use Assembly w/
Baskets**Do Not package - will be assembled on D350-607-143
81563/81564*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Accept

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Start Date: 15/03/2012 **Start Qty:** 2.00

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Cust Item ID:

Required Date: 13/04/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

130

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-607-143
Location: _____
PPP rev: _____

0.00
N
A
0.00

h

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

12/4/17 JJ

*MF
12-04-17*

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March-15-12 1:01:07 PM

Page 1

Work Order ID: 81572

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC

IPP RevB: as
IPP Rev:C as per ecn10-

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-7		Manufactured	No			110	Each	12.0000	1	2			**

D3953-7

Spring Spacer

Location	Loc Qty	Loc Code
ST075	12	
76295	12	

D3953-3

D3953-3

Gas Spring Stud, Lid

Location	Loc Qty	Loc Code
ST075	24	
76659	4	
78042	20	

D3953-5

D3953-5

Gas Spring Stud, Base

Location	Loc Qty	Loc Code
ST075	11	
77506	11	

D3953-9

D3953-9

Gas Spring Washer

Location	Loc Qty	Loc Code
ST075	16	
78916	16	

382045 SP

SP 382044

SP

SP

21

382035

SP Double

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-15-12 1:01:07 PM

Page 2

Work Order ID: 81572

81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3953-11

Manufactured No

110 Each 14.0000

1 2

**

SP

D3953-11

Gas Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST075	14	
71268	2	
79338	12	

2X 1X SP

D3953-15

Manufactured No

110 Each 24.0000

1 2

**

SP

D3953-15

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST075	24	
71269	3	
79337	21	

2X SP

D3953-17

Manufactured No

110 Each 5.0000

1 2

**

B81206 SP

D3953-17

Gas Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST075	5	
76294	5	

2X SP B-04-16

D3969-1

Manufactured No

110 Each 14.0000

1 2

**

SP B-04-16 2X

D3969-1

Spring (Basket Lid)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	14	
73523	14	

W/O:		WORK ORDER CHANGES					
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March-15-12 1:01:07 PM

Page 3

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C11A

Purchased

No

110

Each

58.0000

2

4

**

SP

AN3C11A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	58	
118838	8	
119798	50	

AN3C15A

Purchased

No

110

Each

47.0000

2

4

**

4X

AN3C15A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	47	
119973	47	

AN310-4

Purchased

No

110

Each

72.0000

2

4X
4

**

SP 12-04-16.

AN310-4

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST344	72	
120124	22	
120518	25	
121011	25	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-15-12 1:01:07 PM

Page 4

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81572

Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

818.0000

4

**

8

m 12/255

SP-

MS21043-3

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
GA	316	
120693	316	
ST301	430	
118077	2	
118614	378	
118686	30	
119758	20	

MS24665-2-12

Purchased

No

110

Each

148.0000

2

**

4

SP.

MS24665-2-12

COTTER PIN

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	148	
118078	148	

NAS1149C0332R

Purchased

No

118078

110

Each

3,541.000

4

**

8

4x

NAS1149C0332R

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	3541	
118354	515	
119736	196	
120648	2830	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March-15-12 1:01:07 PM

Page 5

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

110

Each

2,562.000

2

4

**

SP 12-04-16

NAS1149C0432R

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	2562	
117291	1562	
119124	1000	4.

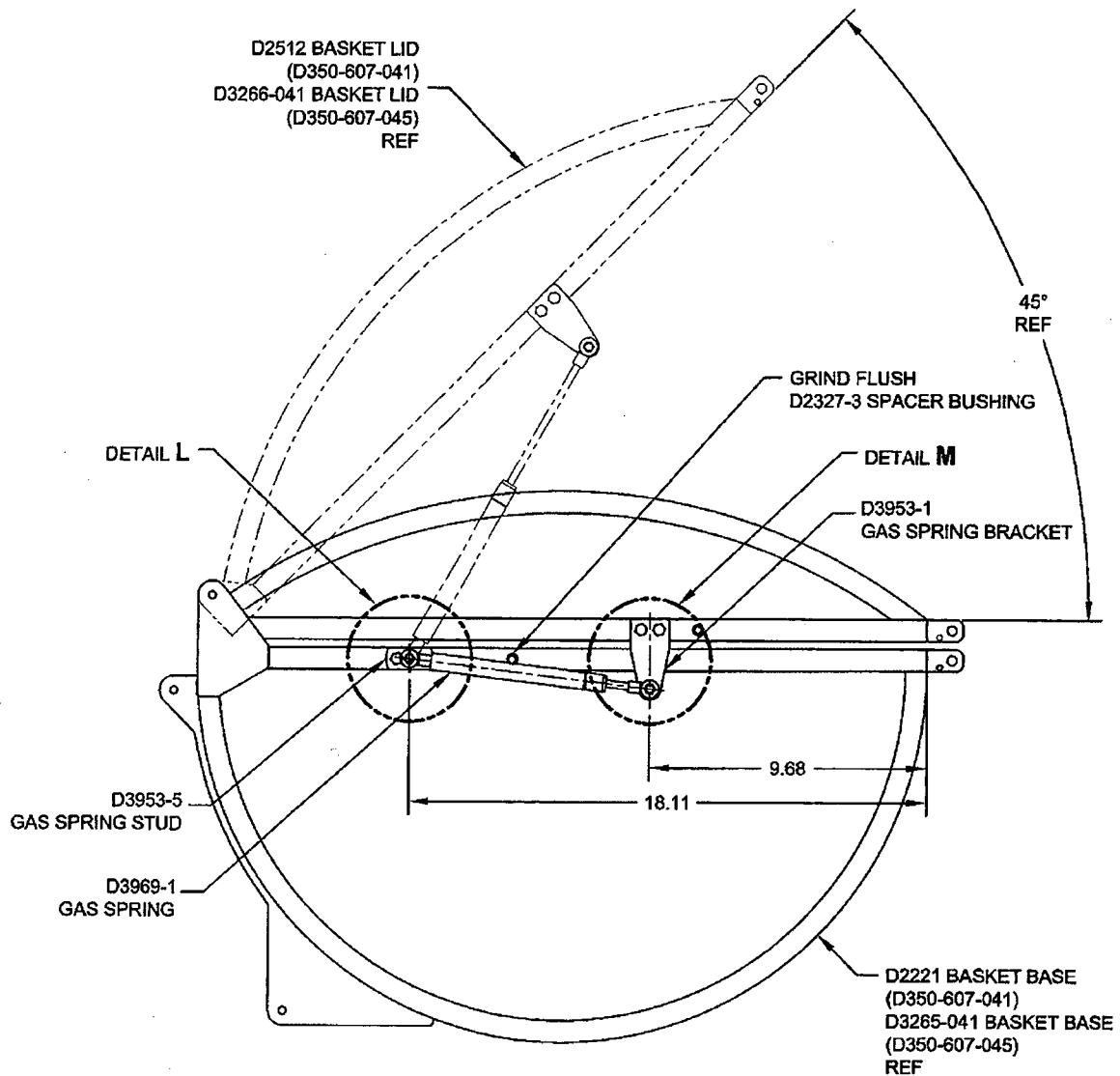
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-607-141 AUTOMATIC LID OPENER INSTALLATION
(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 8a – Automatic Lid Opener Installation

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO WORK ORDER
15/11/01

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